

Work Order ID 81702

Friday, March 16, 2012 2:53:51 PM

81702

Page 1

Item ID: D4016-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Half, Base
 Start Date: 3/19/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 3/23/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-03-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4016	A

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 1.00" LONG								

Handwritten: 12/03/28, 16, 16

110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA869 AND DWG								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>A</u>								
	DEBURR								

Handwritten: 12/03/29, 16, 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81702

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Item ID: D4016-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Base

Start Date: 3/19/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 3/23/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

B.A 12/03/29

16 0

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

2e 12-3-30

16 0

160

Identify as per dwg & Stock Location: **STWA**

0.00

160

Packaging

Memo

0.00

Packaging

(16x) SP 12-03-30

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Picklist Print

Friday, March 16, 2012 2:53:50 PM

Page 1

Work Order ID: 81702

Parent Item: D4016-1

Parent Item Name: Hinge Half, Base

Start Date: 3/19/2012

Required Date: 3/23/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B as per dwg REV.A DD
10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000 304 bar 1.00 x 1.00		Purchased	No			100	f	9.8346	0.08	1.28			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT050		9.8346							
				113290		1.047							
				117130		0.7316							
				118844		8.056							

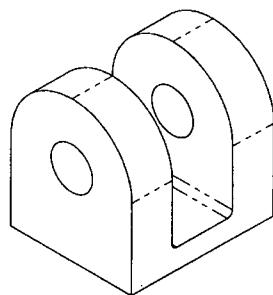
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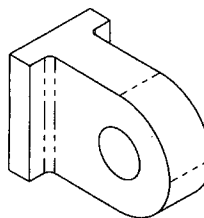
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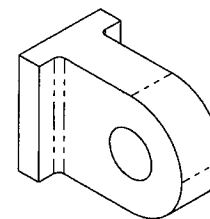
NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

#81702

RELEASED
2010-02-16
MD

A	NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	[Signature]	DRAWING NO.	REV. A	
MFG. APPR.	[Signature]	D4016	SHEET 1 OF 2	
APPROVED	[Signature]	TITLE	SCALE	
DE APPR.	[Signature]	BASKET HINGE	NTS	
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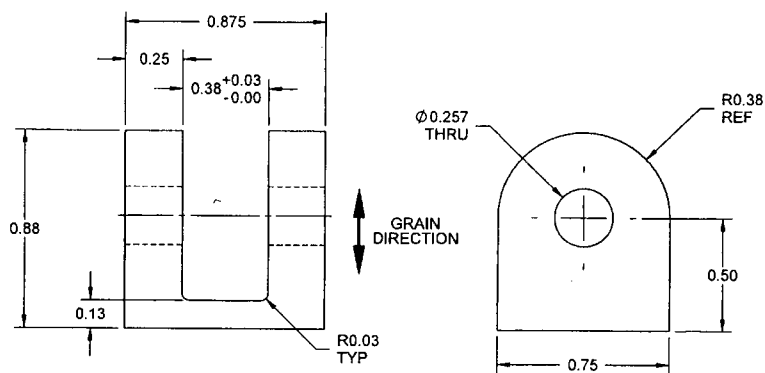
Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

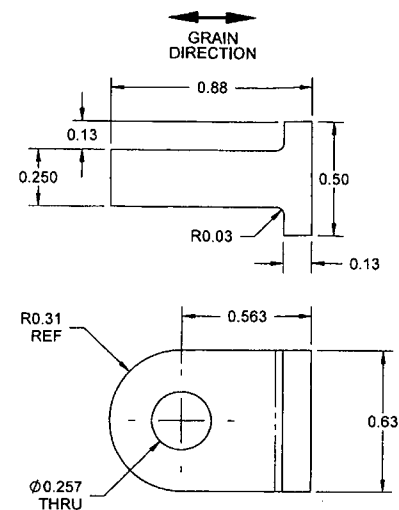
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

371
121
1499

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DART AEROSPACE LTD		Work Order: 81702
Description: Hinge Half, Base		Part Number: D4016-1
Inspection Dwg: D4016	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.875	✓		Vern	GA-01
0.25	+/-0.030	0.242	✓		"	"
0.38	+0.030/-0.000	0.391	✓		"	"
R0.03	+/-0.030	R0.032	✓		R-G	ref.
0.13	+/-0.030	0.133	✓		Vern	GA-01
0.88	+/-0.030	0.875	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.258	✓		"	"
R0.38	+/-0.030	R0.375	✓		R-G	ref.
0.500	+/-0.030	0.500	✓		Vern	GA-01
0.75	+/-0.030	0.750	✓		"	"

Measured by: B.A	Audited by: DQ	Preliminary Approval:
Date: 12/03/24	Date: 12-3-33	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

Dart Aerospace Ltd

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